

Work Order ID 85959

85959

Page 1

June-19-12 8:04:35 AM

Item ID: D4150-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Plate

Start Date: 19/06/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/19 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4150

B

DB

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4150

Prog Rev: 8

Dwg Rev: 15

304 . 125"

Deburr as required

12-6-21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-6-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 85959

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24

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 24.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

28

12-06-21

150

Identify as per dwg & Stock Location **ST-102** 0.00

150

Packaging

Memo

0.00

Packaging

28

12-06-28

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/25

MF
12-06-25

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-19-12 8:04:39 AM

Page 1

Work Order ID: 85959

85959

Parent Item: D4150-3

D4150-3

Parent Item Name: Arm Plate

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	67.3260	0.0254	0.641684	1		

M304S11GA

304/316 0.125 Sheet

**

B12-6-21

Location

Loc Qty

Loc Code

MAT020

67.326

121380

24.9

121780

42.426

121780

58

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

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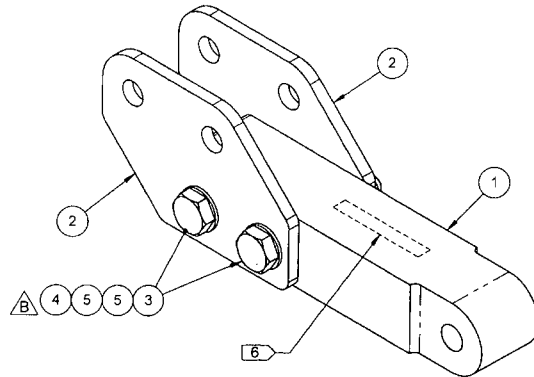
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER



D4150-041 ATTACHMENT ARM ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85959 MLJ
12/06/19

RELEASED
2010-07-16
MD

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.82 lbs

B	REPLACED QTY(3) MS20815-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø.191 2 PL REPLACES Ø.129 3 PL (ZN C6-2, C7-2, B4-3 & B5-3). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.08
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4150** REV. B
TITLE **ATTACHMENT ARM ASSY** SCALE NTS
SHEET 1 OF 3

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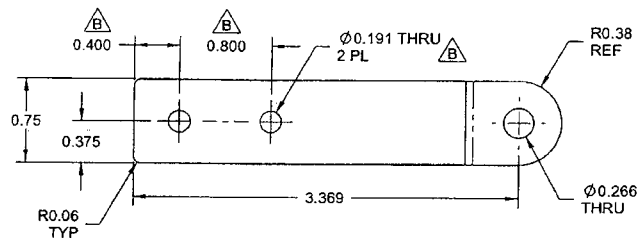
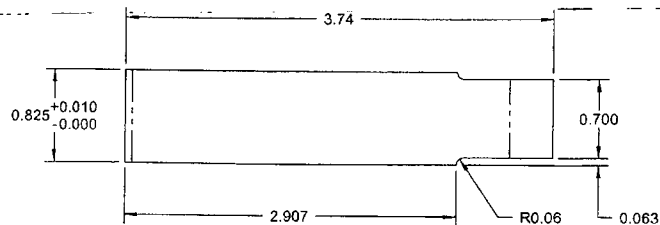
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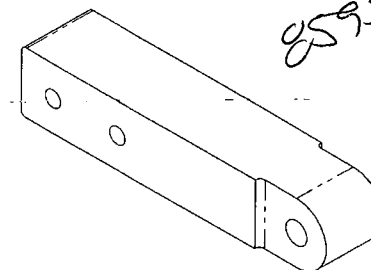
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NOTE: Date & initial all entries



D4150-1 ARM



85959

RELEASED
 2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
 REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
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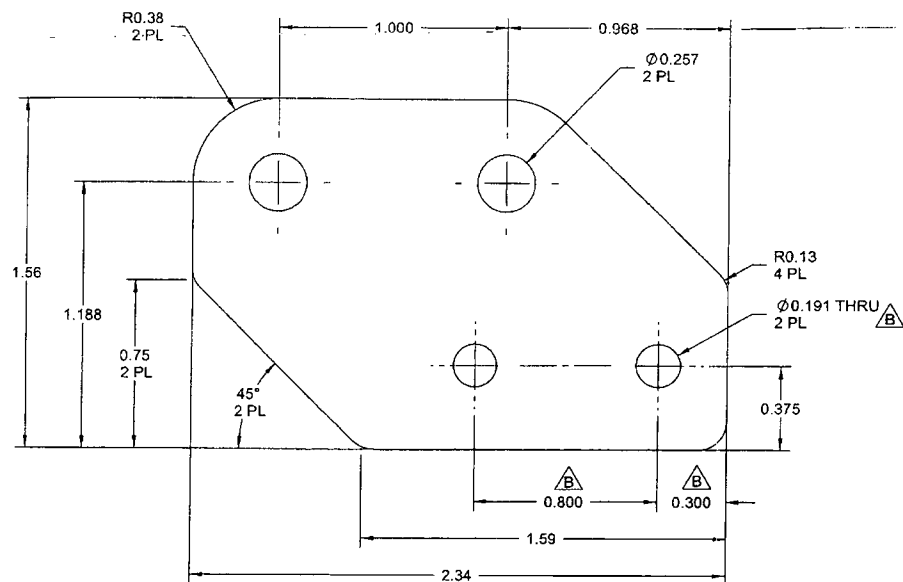
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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25959



D4150-3 ARM PLATE

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 3 OF 3
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